

**\*80087\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Customer:**

**\*10\***

**\*10\***

Run Start \*NR1\*

Date: 12/02/10 Tooling:

Date:

Stop \*NR2\*

**QC:**

Date:

**SPC (Y/N):**

Date:

100

0.00

\*100\*

0.00

### Cold Saw

## Memo

Hyd Mech

CUT TO LENGTH AS PER DWG

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

0.00

QC

## Memo

## Quality Control

120

Manufacture as per dwg

0.00

**\*120\***

0.00

Mill Conv

## Memo

### Conventional Milling Machine

DRILL HOLES AS PER DWG

W/O: 80087 <i>Kernichy</i>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/14/14	#110	Remove this step not necessary	<i>[Signature]</i>	12.03.15			<i>[Signature]</i> 12/14/14

Part No: D4526-043 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 80087

\*80087\*

Page 2

February-09-12 4:28:40 PM

Item ID: D4526-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tube Assembly  
 Start Date: 09/02/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 23/02/2012 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC6- Inspect dimensions to drawing	0.00							
*130*									
QC	Memo	0.00							
Quality Control									
140		0.00							
*140*									
Large Fab	Memo	0.00							
Large Fab	1- WELD CAP AS PER DWG								
	2- GRIND ONLY THE ENDS FLUSH, TOP WILL BE MACHINE AS PER DWG								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

8/26/14

(X10)

EL 12-2-22 (X10)

Pl 12-02-23 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*80087\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

\*10\*

**Cust Item ID:**

\*10\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Tooling:**

Date:

Stop **\*NR2\***

**SPC (Y/N):**

Date:

**Insp.  
Stamp**

0.00

**\*160\***

0.00

Lathe Conv

## Memo

### Conventional Lathe

TURN ENDS AS PER DWG

0.00

**\*170\***

0.00

QC

## Memo

## Quality Control

0.00

**\*180\***

0.00

HandFinish

## Memo

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80087

February-09-12 4:28:40 PM

**\*80087\***

Page 4

Item ID: D4526-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tube Assembly  
 Start Date: 09/02/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 23/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	QC3- Inspect Part Finish	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control	PART MUST BE DRY INSIDE								

200	Identify as per dwg & Stock Location: <b>ST 254</b>	0.00							
<b>*200*</b>									
Packaging	Memo	0.00							
Packaging									

210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

10 BL 12-3-12

(10X) SP4-03-13

12/3/15

112-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February-09-12 4:28:44 PM

Page 1

Work Order ID: 80087

\*80087\*

Parent Item: D4526-043

\*D4526-043\*

Parent Item Name: Tube Assembly

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	88.3824	2.3458	24.69263			

\*M6061T6T1 000W 188\*

6061T6 RD TUBE 1.00 X .188W

\*\*

Location	Loc Qty	Loc Code
MAT016	88.382368	
109041	3	
114089	0.227368	
115868	1.435	
117798	83.72	

D4526-3

Manufactured No

140 Each 16.0000

2

20

\*D4526-3\*

Cap

\*\*

Location	Loc Qty	Loc Code
WA	16	
17213	16	
80515	4	

25. 12/02/13

12-2-22

16

4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# FIRST ARTICLE INSPECTION CHECKLIST

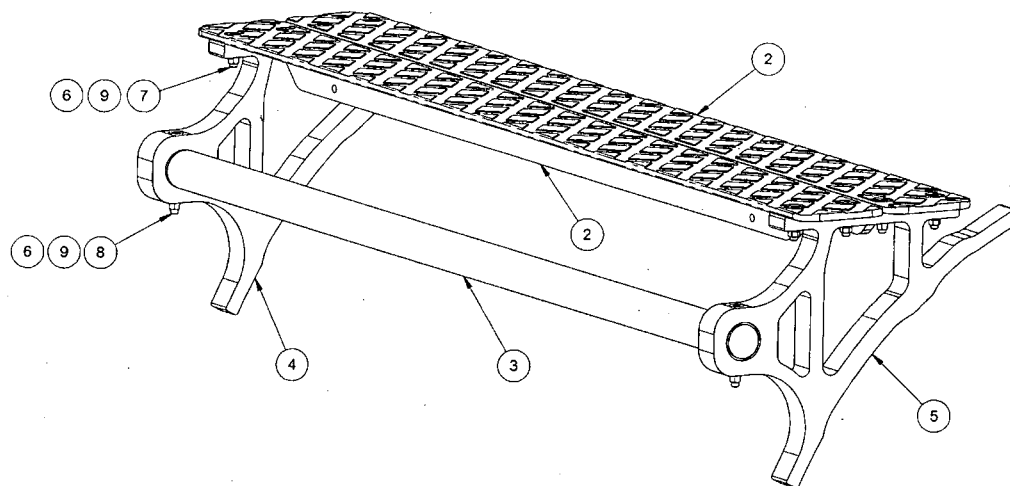
DART AEROSPACE LTD		Work Order: 80087
Description: Tubing		Part Number: 4526-1
Inspection Dwg: 4526		Rev: 4
Page 1 of 1		

☒ First Article   
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
28.15	±.030	28.15	—	—	—	RA 04	Tape
27.56	±.030	27.56	—	—	—	RA 04	Tape
.295	±.010	.296	—	—	—	RA 2C	Vern
φ.201	±.004	.201	—	—	—	RA 2C	Vern
.750	±.030	.750	—	—	—	51-5	Mre
.999/.995	±.000	.997	—	—	—		

Measured by: <i>SL</i>	Date: 12/3/9	Audited by: <i>S</i>	Date: 12/3/9	Prototype Approval: _____	Date: _____
Rev	Date	Change	Revised by	Approved	
A		New Issue	KJ/MLM		

201



**D4526-042 MAINTENANCE STEP ASSEMBLY**

ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

80087 M.C.J.  
12/02/10

**RELEASED**  
2011-11-28

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4526	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.11.22	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

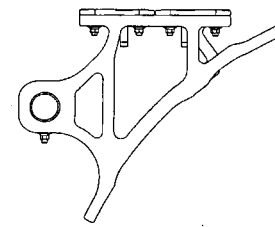
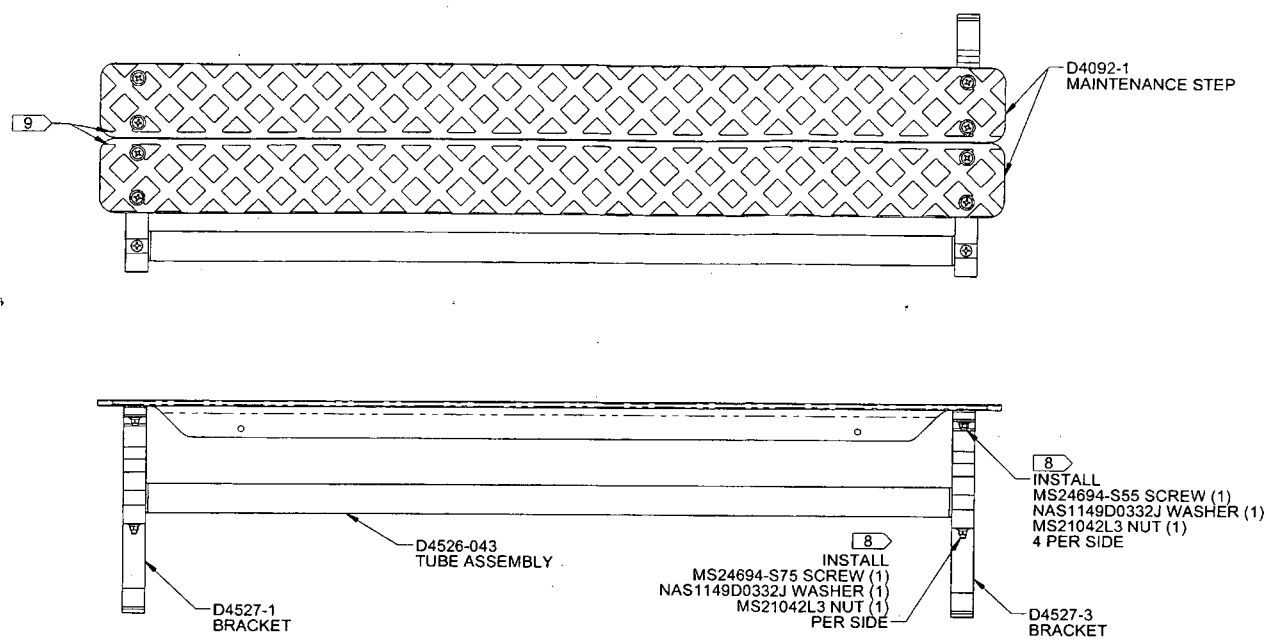
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80087



**D4526-042 MAINTENANCE STEP ASSEMBLY**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER QSI 044 6.1
  - 7) WEIGHT: 7.09 lbs
  - 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
  - 9) GRIP CUTOUT TOWARD CENTER

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2011-11-28  
*WDP*

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DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4526</b>	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

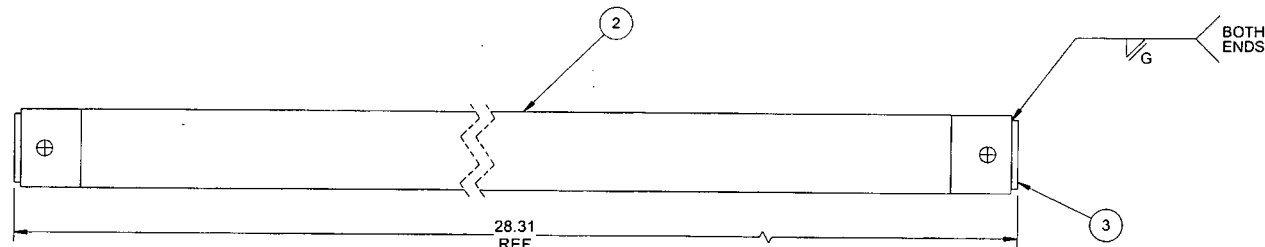
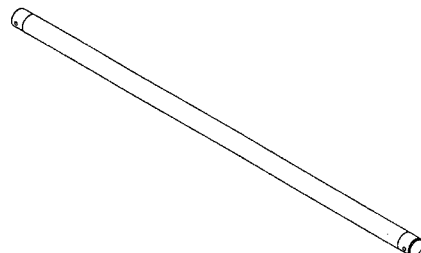
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



00087

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP



**D4526-043 TUBE ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

**RELEASED**  
2011-11-28  
WJD

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4526</b>	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

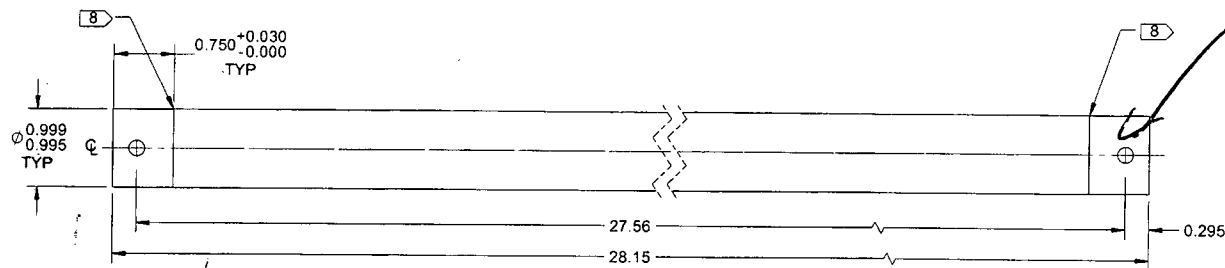
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

20087



2011  
See E-MA-1  
ATT. *[Signature]*  
12-02-14

**D4526-1 TUBING**

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

**RELEASED**  
2011-11-28  
*[Signature]*

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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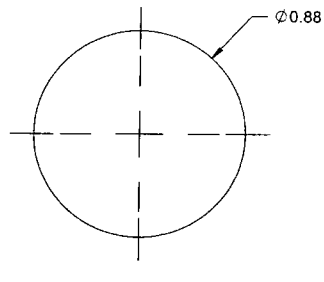
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80087



**D4526-3 CAP**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

**RELEASED**  
2011-11-28

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DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4526</b>	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**From:** Roberto Fuentes <rfuentes@dartaero.com>  
**Sent:** Tuesday, November 29, 2011 2:45 PM  
**To:** Jean-Luc Menard  
**Cc:** David Shepherd  
**Subject:** D4526-1 Tubing

JL,

The hole diameter in both end of the D4526-1 Tubing is  $\varnothing 0.201"$ . The drawing will revise after pass conformity inspection of this new maintenance step by ERA.

Thanks to let know,  
Roberto